

Work Order ID 77587 -2

\*77587\*

Page 1

Tuesday, December 13, 2011 2:44:04 PM

Item ID: D3255-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Access Panel Assembly  
 Start Date: 12/13/2011 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 1/5/2012 Req'd Qty: 3.00 \*3\* Customer:

Reference: Run Start \*NR1\*  
 Approvals: Process Plan: *P* Date: 11/12/13 Tooling: Date:  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3255	Rev B

100	Large Fab	0.00							
*100*	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld***A/R SS ROD								
Large Fab	Batch: 4115778 2-Grind Welds Flush								

110	QC10- Inspect visual per QSI004- ground welds	0.00							
*110*	Memo	0.00							
QC									
Quality Control									

120	QC5- Inspect part completeness to step on W/O	0.00							
*120*	Memo	0.00							
QC									
Quality Control									

*SY 11.12.29 (2x)*

*8 11/12/29*

*8 11/12/29*

*(72) 204*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**\*77587\***

Page 2

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Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<b>*130*</b>									
Powdercoat									
Powder Coating									

*Memo* 11:00 0.00  
 START TIME: 3200- FINISH TIME: 11:30  
 OVEN TEMPERATURE:

*2x M-12/01/02*

140	QC3- Inspect Part Finish	0.00							
<b>*140*</b>									
QC									
Quality Control									

*Memo* 0.00

*M 12 01 03 (2)*

150	Small Fab	0.00							
<b>*150*</b>									
Small Fab									
Small Fab									

*Memo* 0.00

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg  
 D3255A/R 736 DOW CORNING ADHESIVE  
 Batch: *M116664*

*M 12 01 03 (2)*

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**\*77587\***

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Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		5 12/01/04		(+2) -042			
170 <b>*170*</b> Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00  0.00		SHIP 12/17/0					12/01/04 (2)
180 <b>*180*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							OK 12/01/05 ME 12-01-04



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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, December 13, 2011 2:44:08 PM

Page 1

Work Order ID: 77587

**\*77587\***

Parent Item: D3255-042

**\*D3255-042\***

Parent Item Name: Access Panel Assembly

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3255-2		Manufactured	No			100	Each	7.0000	1	3			
<b>*D3255-2*</b>									**			11.12.23	
Panel													

Location	Loc Qty	Loc Code
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WA025

7

75155

7

D3255-5		Manufactured	No			100	Each	7.0000	1	3			
<b>*D3255-5*</b>									**				
Gasket													

Location	Loc Qty	Loc Code
----------	---------	----------

GA

7

72118

1

75083

6

D3255-3		Manufactured	No			150	Each	29.0000	1	3			
<b>*D3255-3*</b>									**			11.12.23	
Cap													

Location	Loc Qty	Loc Code
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WA022

29

72152

4

75969

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

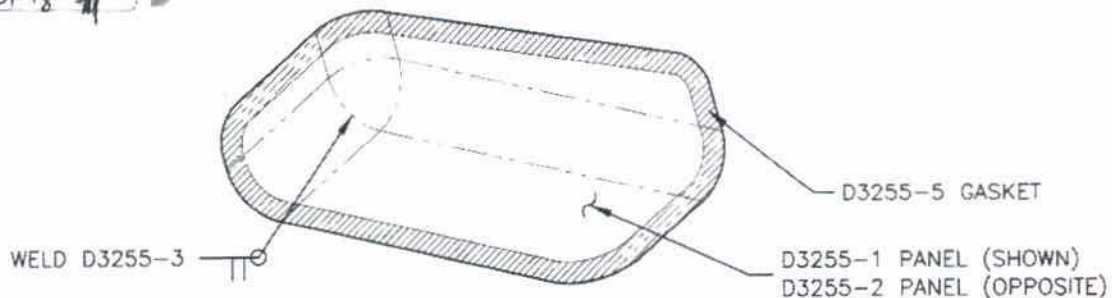
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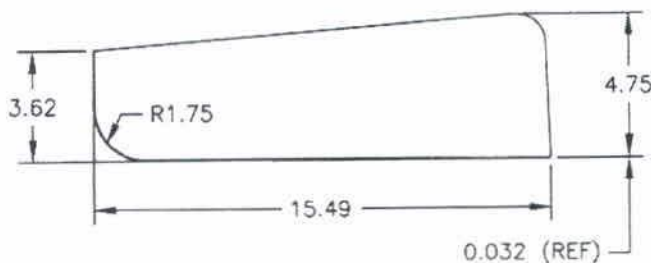
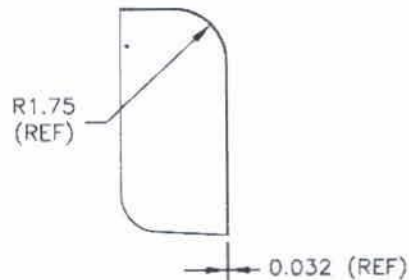
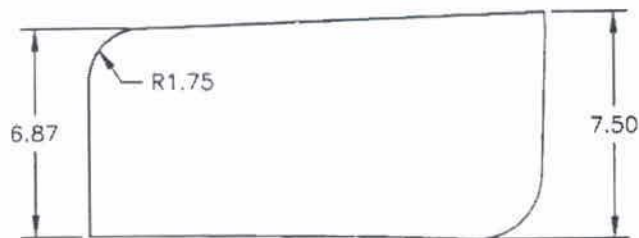


**DART**

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CHECKED <i>if</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED  
05-01-18 #

**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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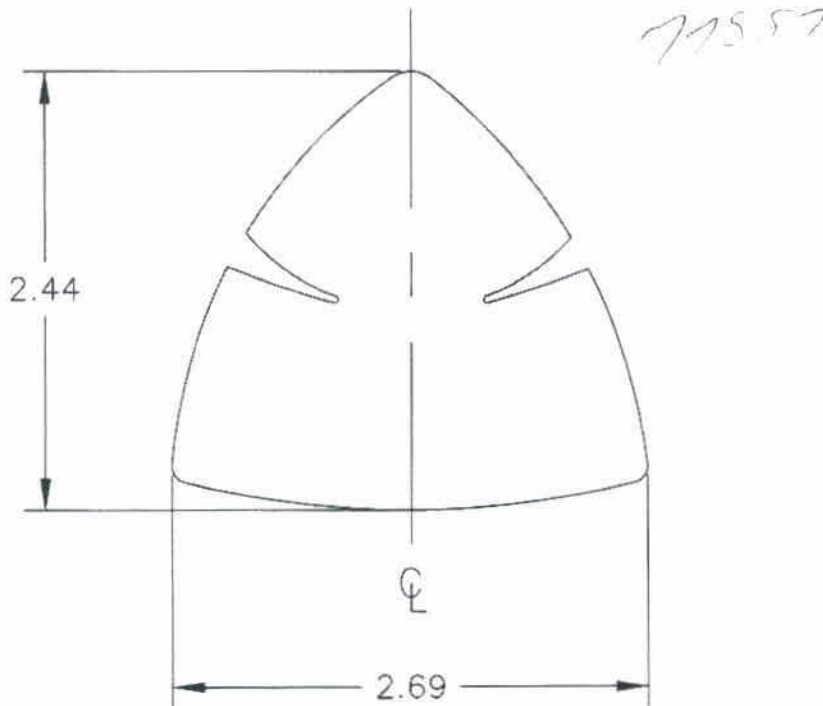
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**DART**

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CHECKED qf	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.08 [Signature]

**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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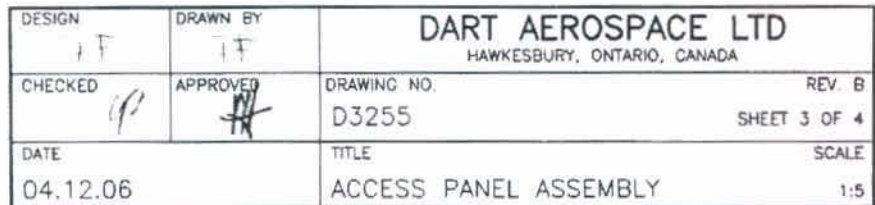
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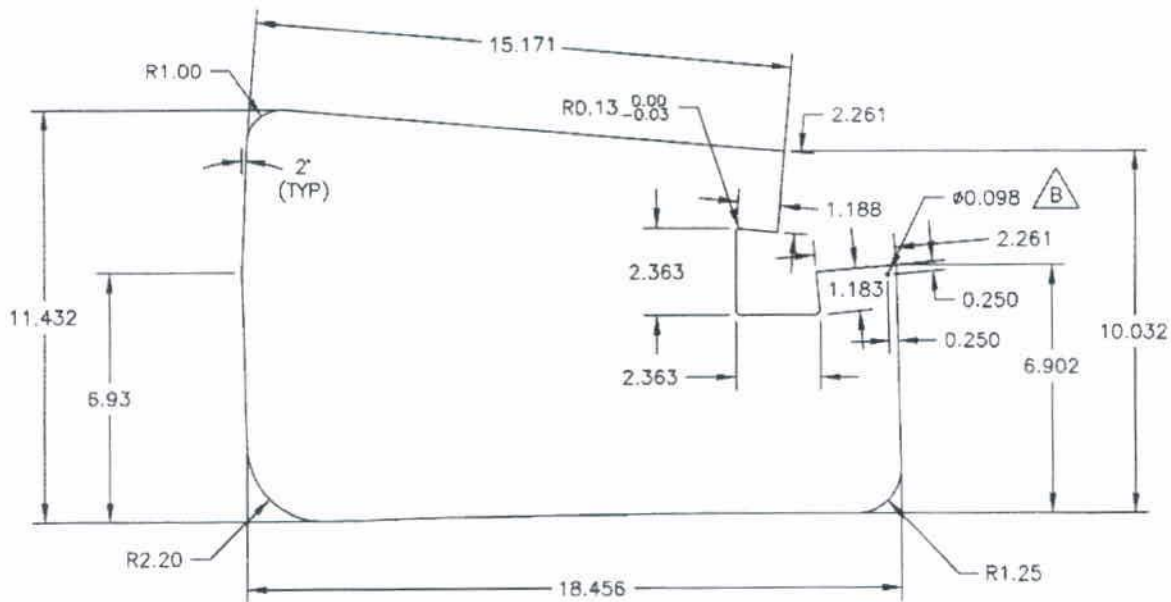
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RELEASED  
05 01 18

77587



D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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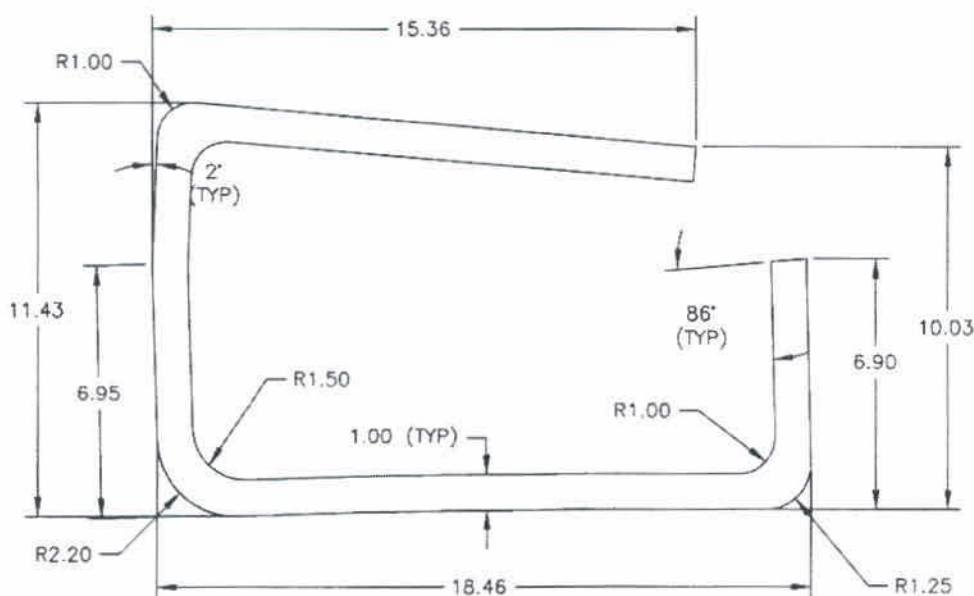
**NOTE:** Date & initial all entries

**DART**

DESIGN JT	DRAWN BY JT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05 01 18 [Signature]

77587

**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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